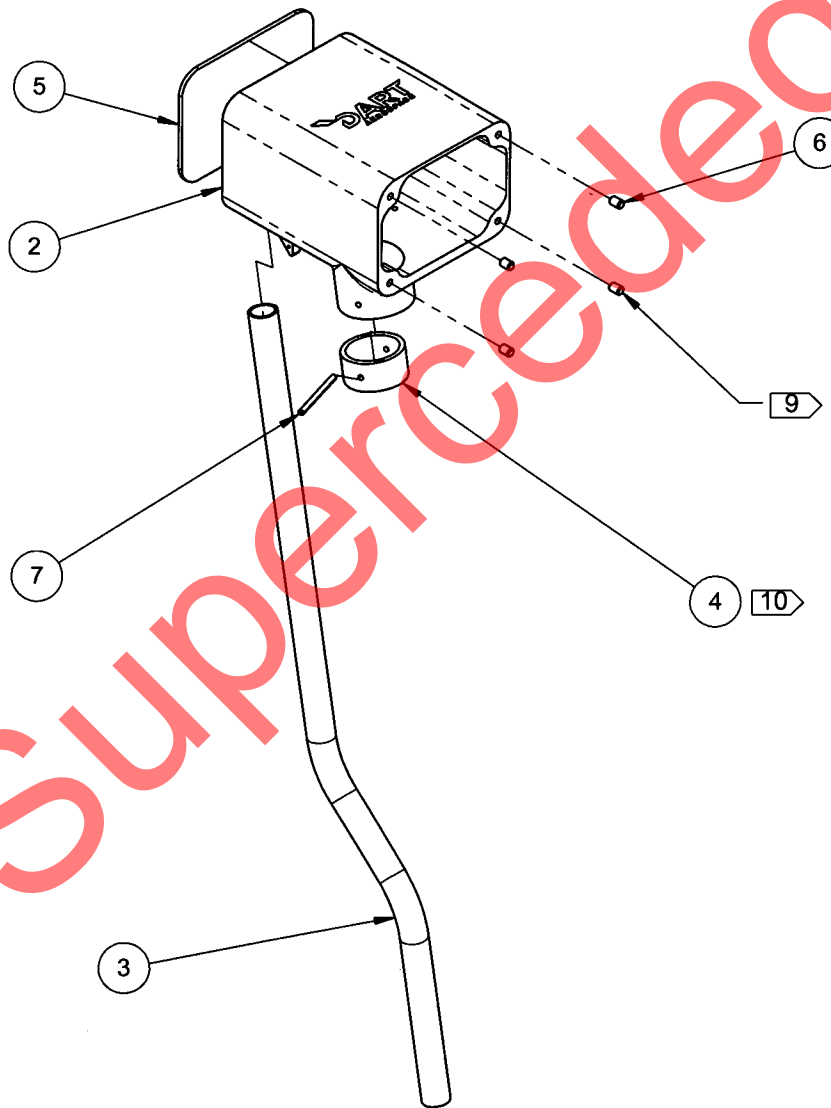


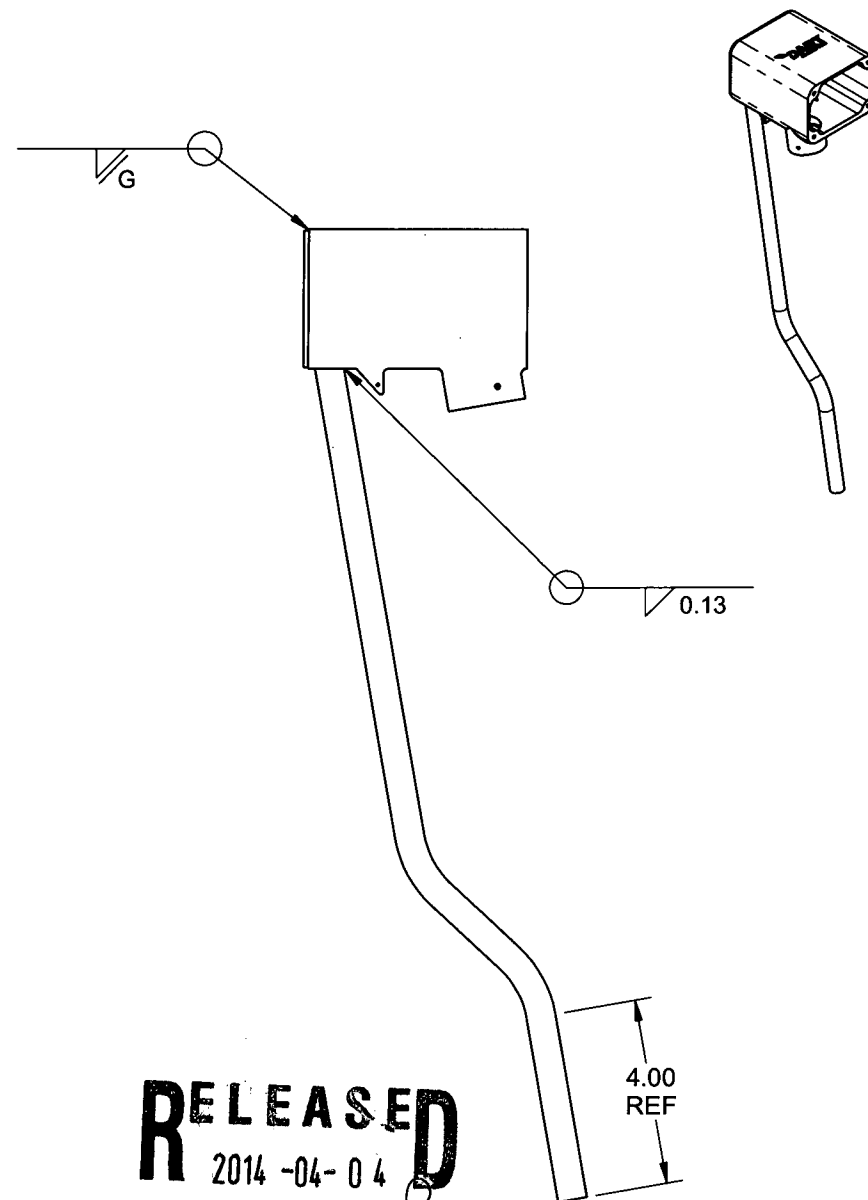
ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4410-041	CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-11	205 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	1	MS171539	PIN



D4410-041 CO-PILOT COLLECTIVE HEAD ASSEMBLY (205)

NOTES:

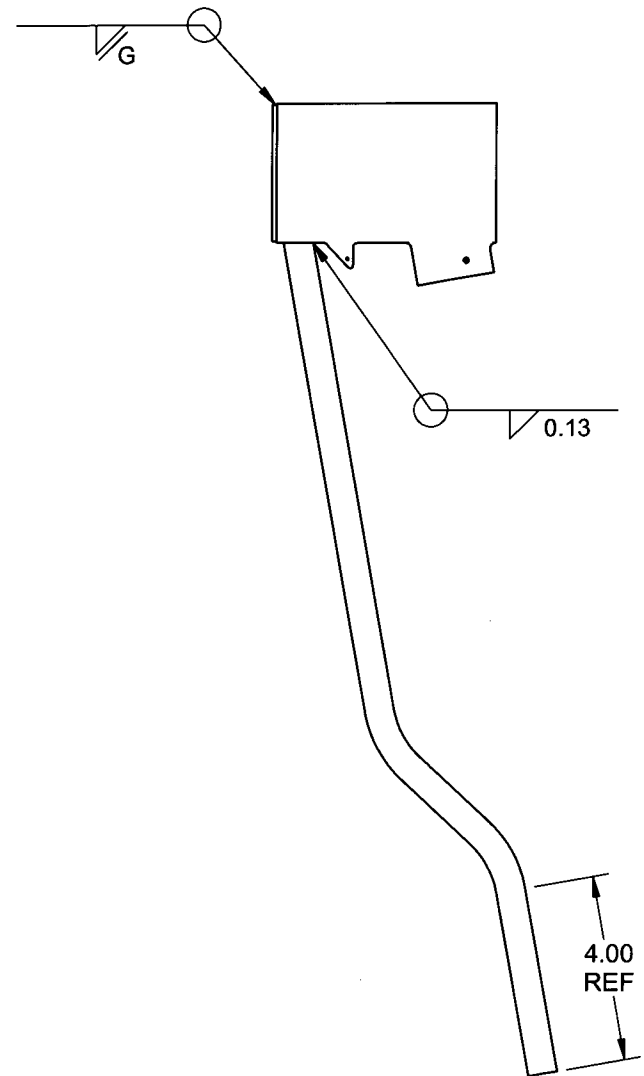
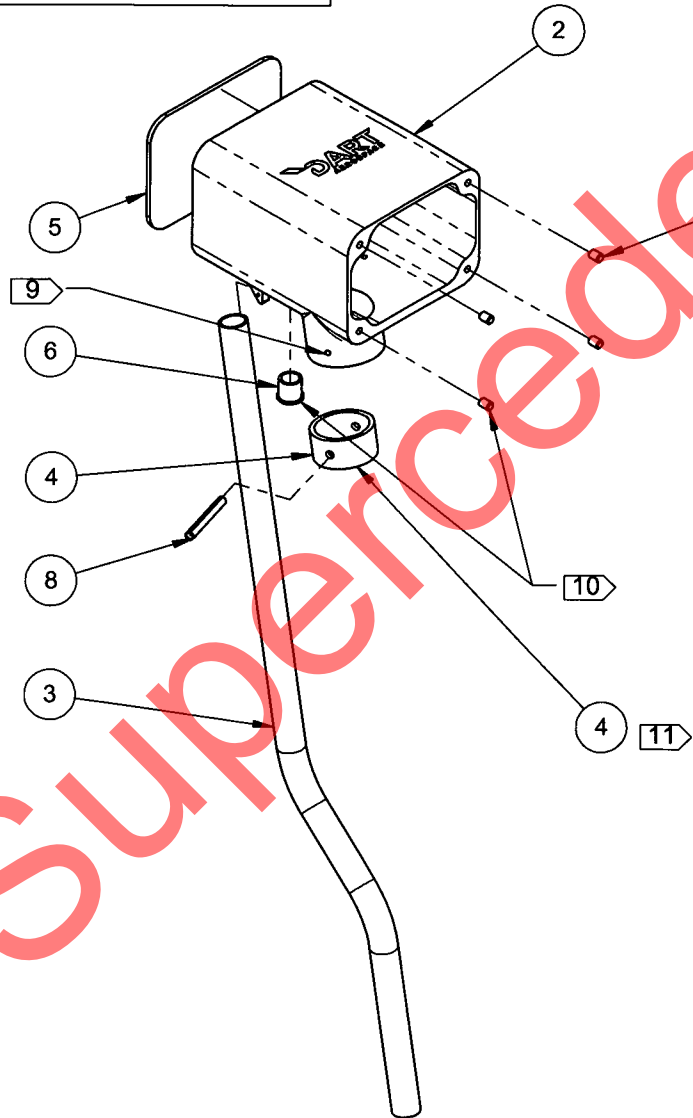
- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.55 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING
- 10) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN



D4410-041 WELDING DETAIL

C	ADD HOLE DIM, ZN C6-7; UPDATE LOGO, ZN C2-5; UPDATE NOTE 8, ZN A8-5; REVISE CAPTION, ZN B2-1; ADD WELDING DETAIL, ZN C2-2, ZN C2-3.	VS	14.02.20
B	ADD C'BORE, ZN A4-2. ENLARGE HOLES, ZN C5-3 & B8-3, UPDATE LOGO. ADD -045/-11/-13/-15. ROTATE HOLE, ZN C3-2. INCREASE -7 DIAMETER, ZN C1-6. REMOVE -9 FROM -041 ASSEMBLY, ZN C5-1.	DC	12.07.30
A	NEW ISSUE	DC	11.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4410	SHEET 1 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4410-043	CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	1	D4413-1	DOME PLUG
7	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
8	1	MS171599	PIN



D4410-043 WELDING DETAIL

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.55 lbs
 - 8) WELD PER DART QSI 004
 - 9) REAM TO Ø0.177 (DRILL #16)
 - 10) INSTALL AFTER ANODIZING
 - 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

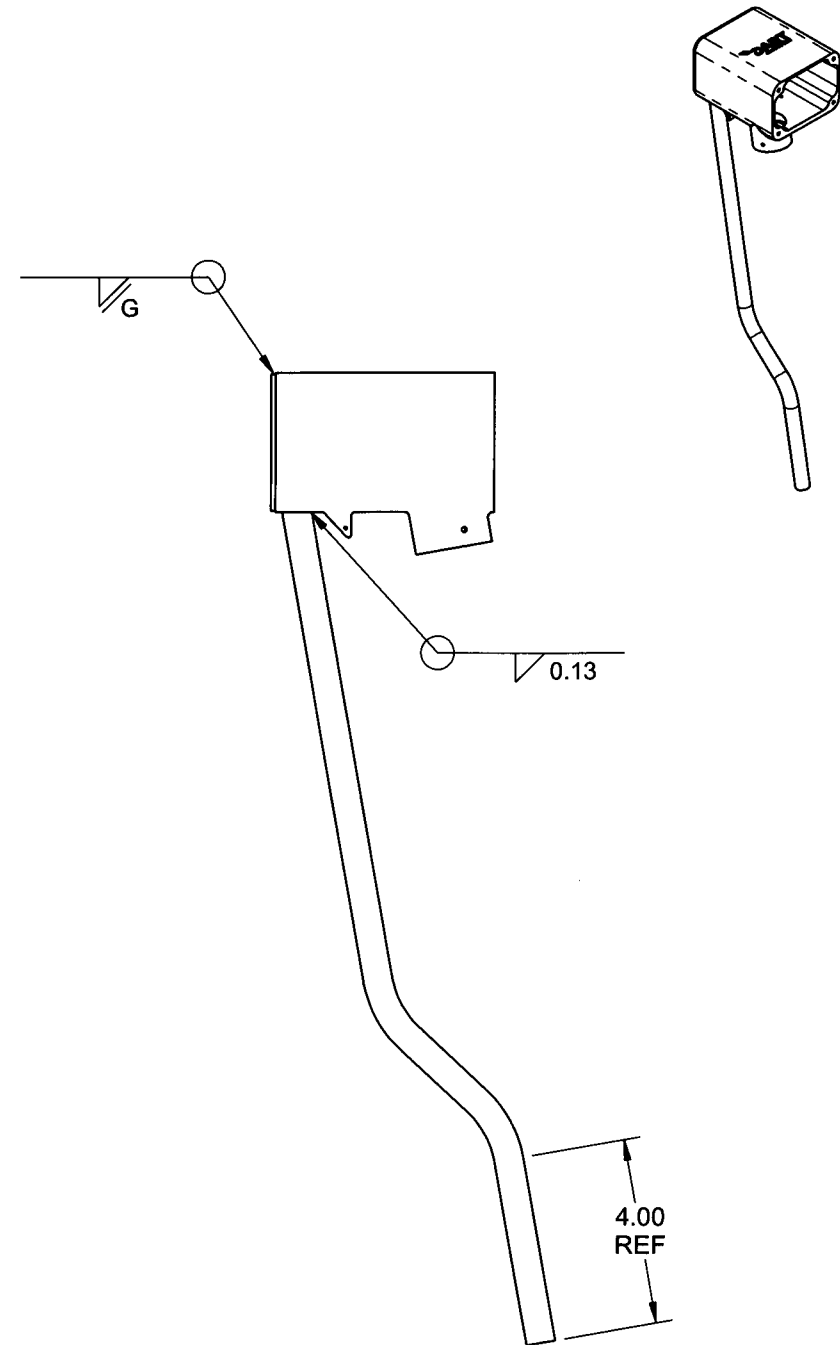
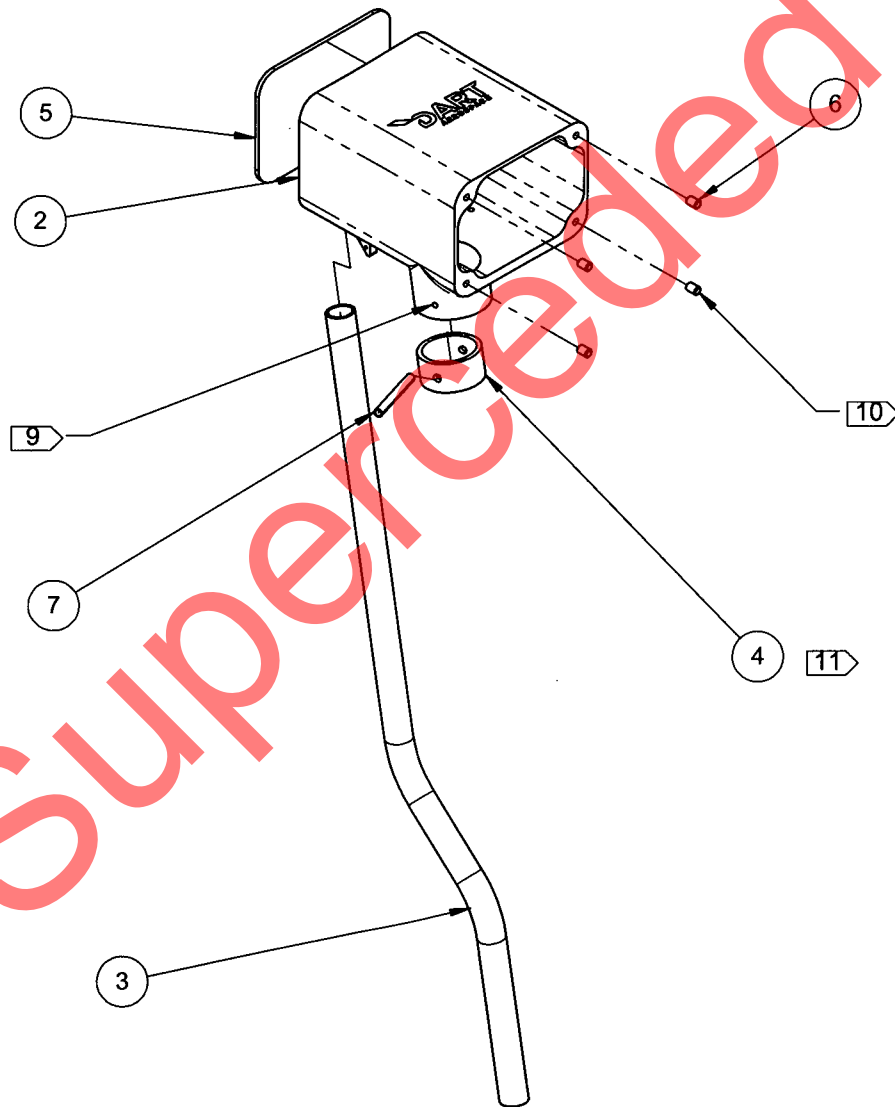
D4410-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

APPROVED

DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4410	SHEET 2 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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RELEASED
2014-04-04

ITEM NO.	QTY. -045	PART NUMBER	DESCRIPTION
1	X	D4410-045	CO-PILOT COLLECTIVE HEAD ASSEMBLY (EAGLE SINGLE)
2	1	D4410-1	CO-PILOT COLLECTIVE HEAD
3	1	D4410-7	CONDUIT
4	1	D4410-13	212 SHIM
5	1	D4410-15	REAR COVER
6	4	90296A108	HELI-COIL INSERT (6-32 X 0.276)
7	1	MS171599	PIN



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.55 lbs
 - 8) WELD PER DART QSI 004
 - 9) REAM TO Ø0.177 (DRILL #16)
 - 10) INSTALL AFTER ANODIZING
 - 11) INSTALL AFTER ANODIZING WET WITH PROSEAL 890 OR EQUIVALENT ENSURE THAT PROSEAL DOES NOT CONTACT PIN

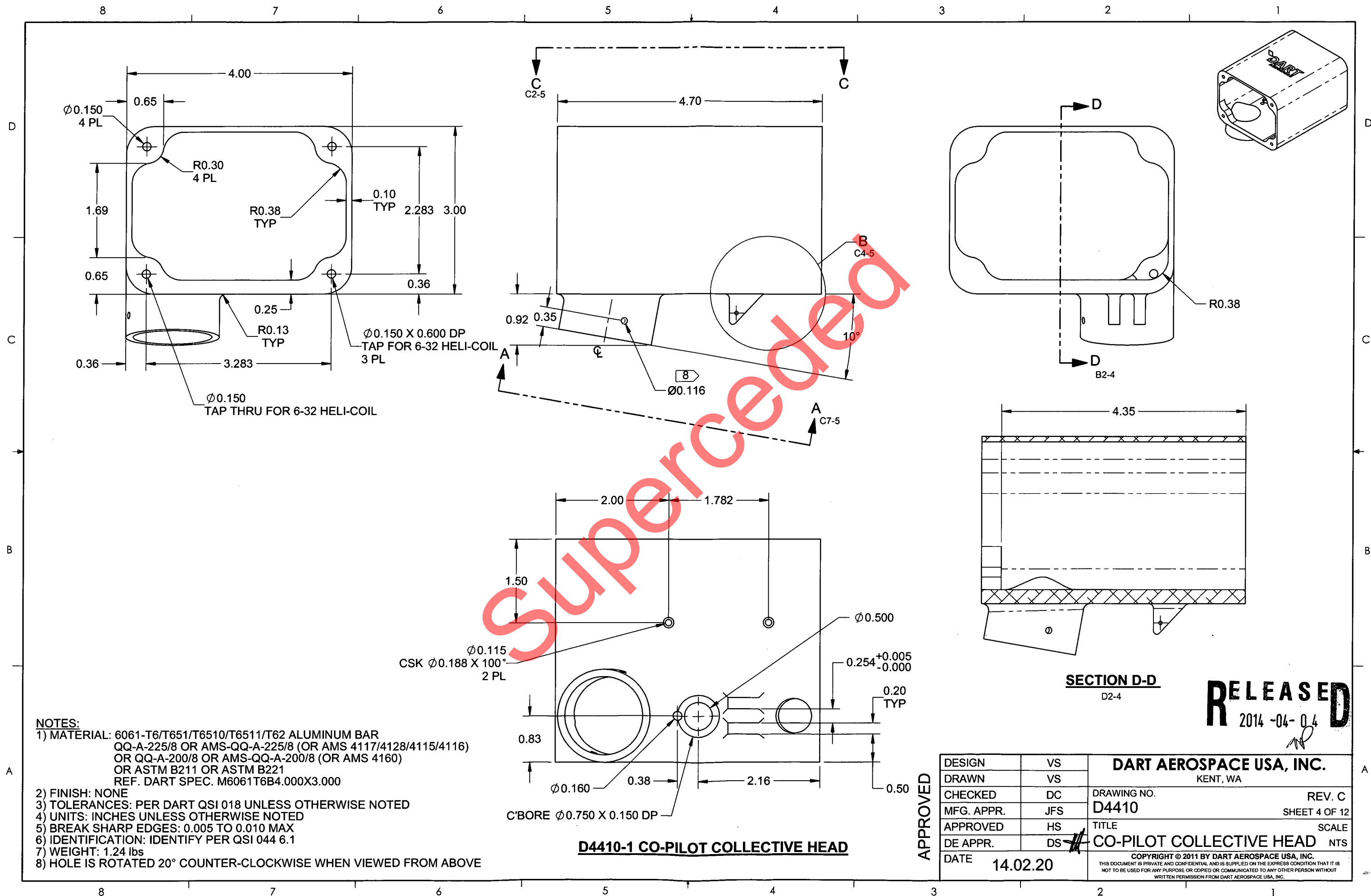
**D4410-045 CO-PILOT COLLECTIVE HEAD ASSEMBLY
(EAGLE SINGLE)**

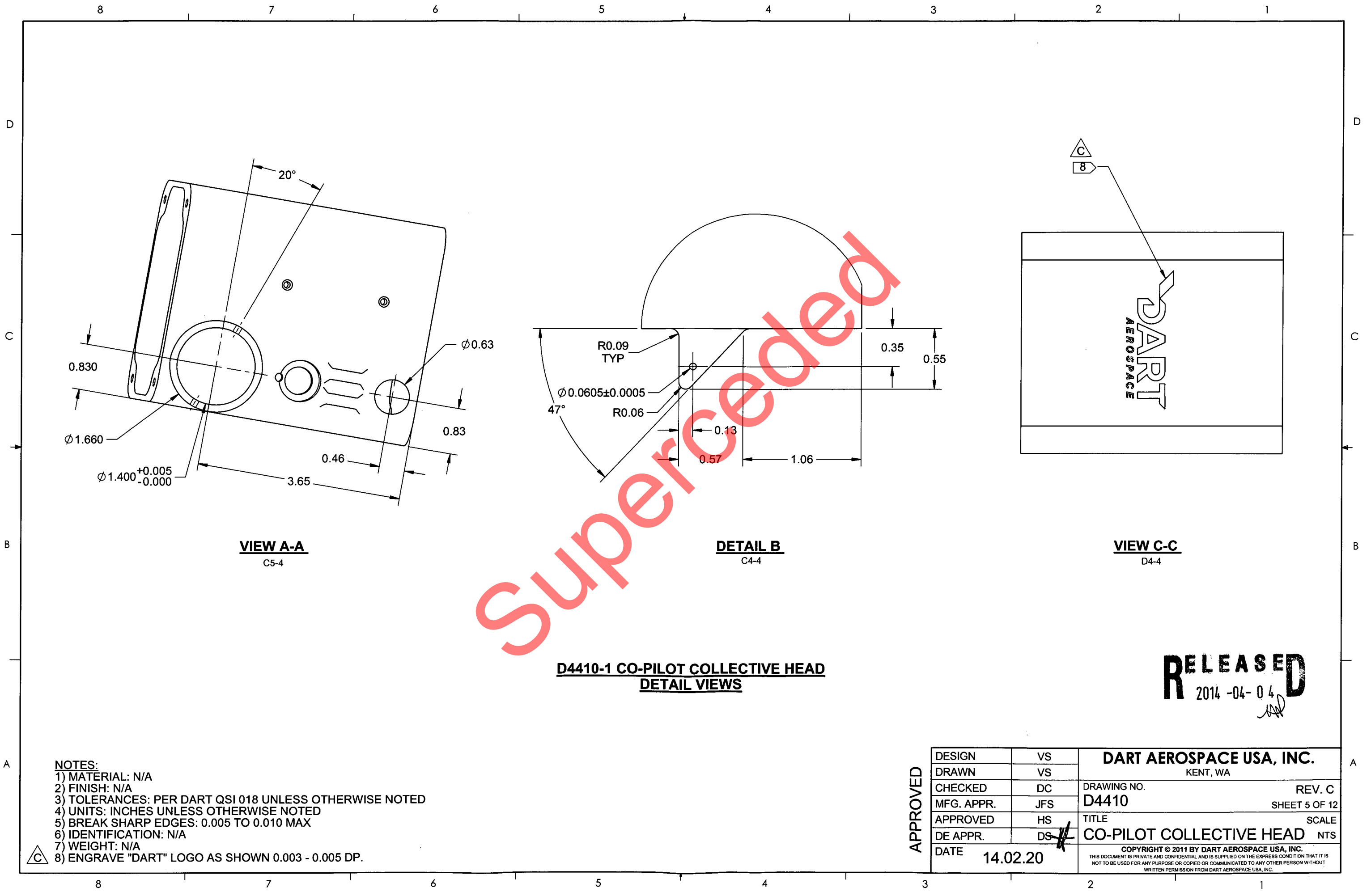
D4410-045 WELDING DETAIL

RELEASED
2014-04-04

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DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4410	SHEET 3 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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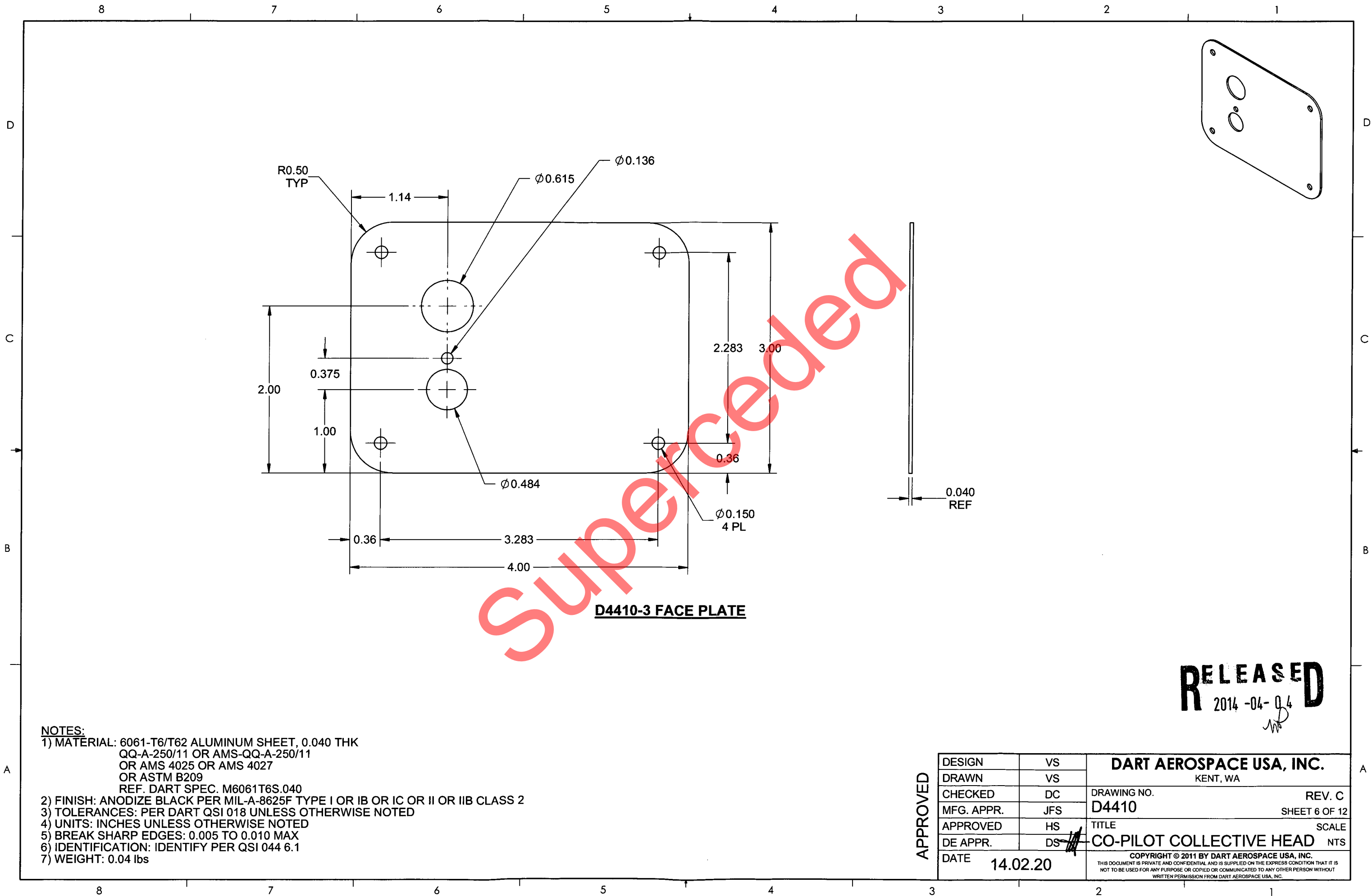
**D4410-1 CO-PILOT COLLECTIVE HEAD
DETAIL VIEWS**

RELEASED
2014-04-04

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: N/A
 - 8) ENGRAVE "DART" LOGO AS SHOWN 0.003 - 0.005 DP.

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DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4410	SHEET 5 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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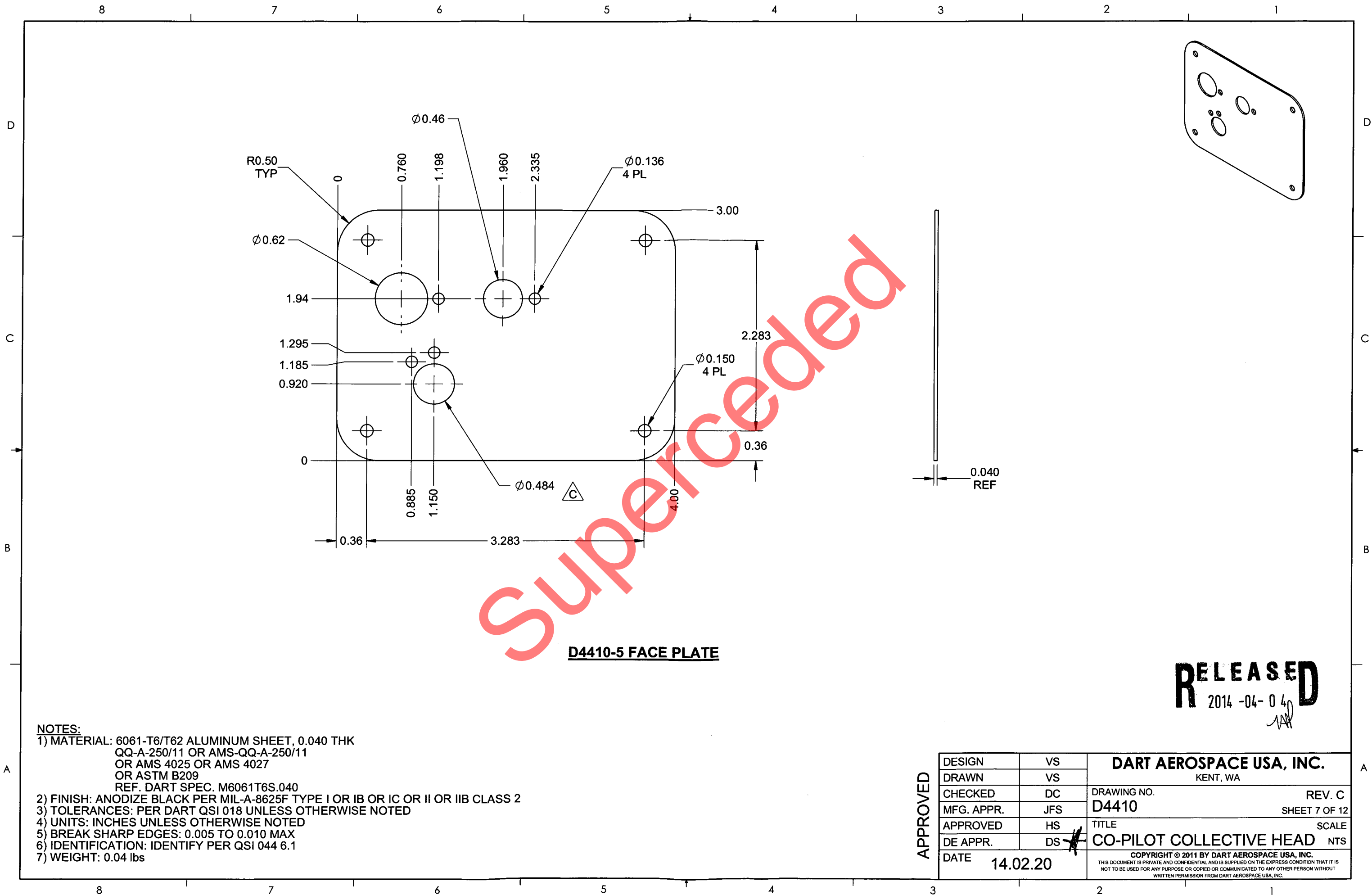


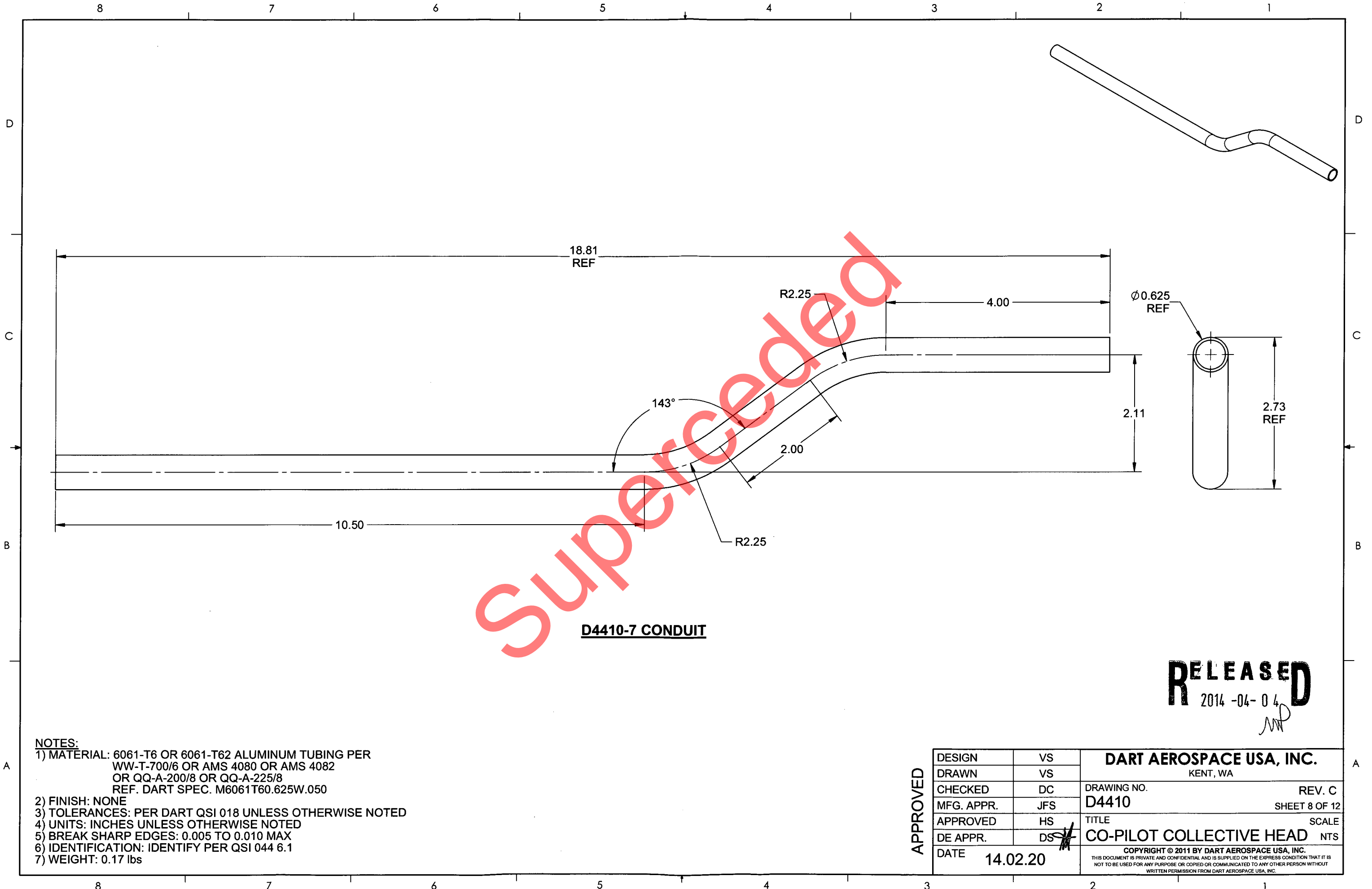
D4410-3 FACE PLATE

RELEASED
2014-04-04
ms

- NOTES:**
1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.040 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.040
2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.04 lbs

APPROVED	DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	VS		
	CHECKED	DC	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4410	SHEET 6 OF 12
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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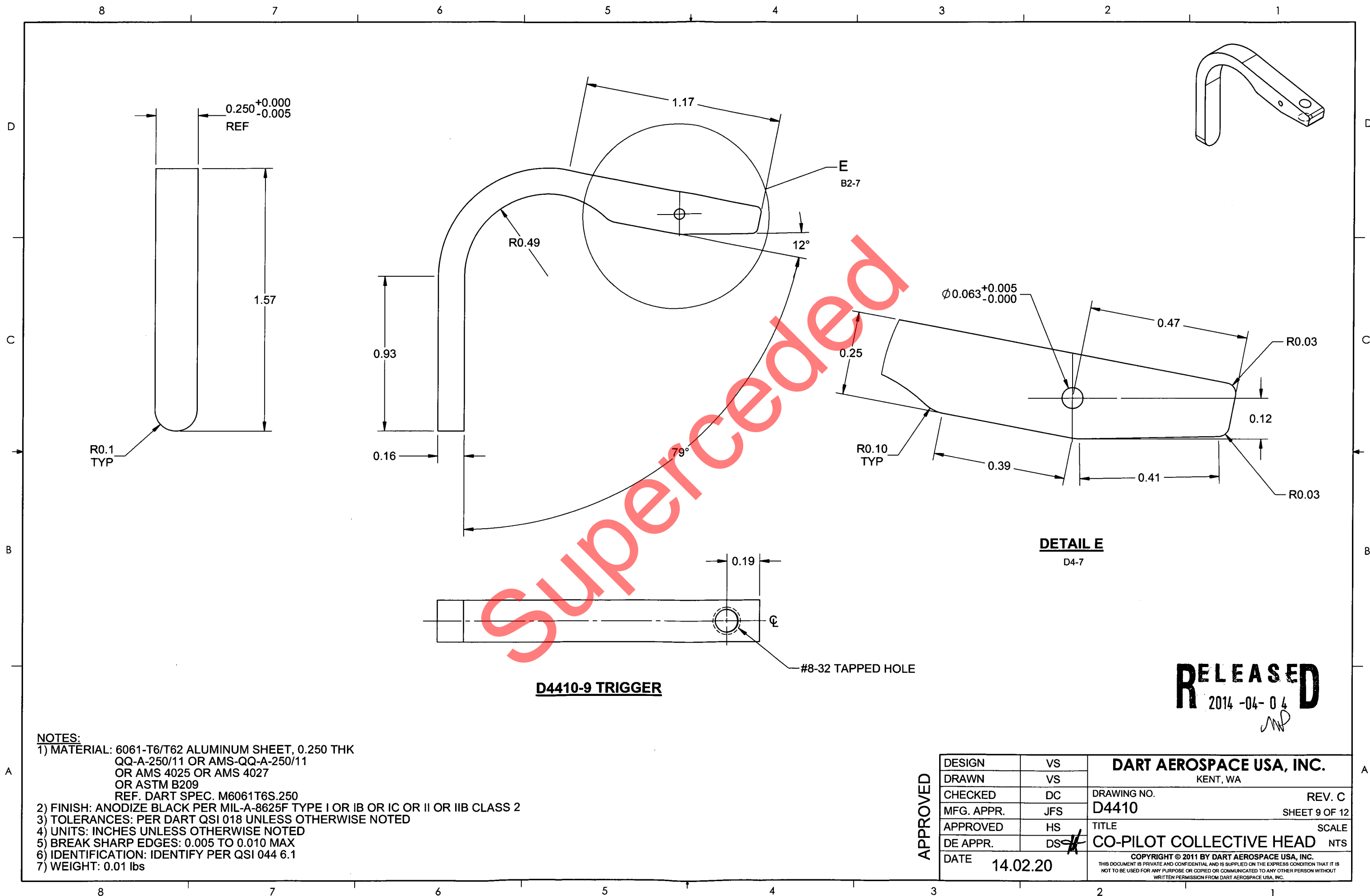


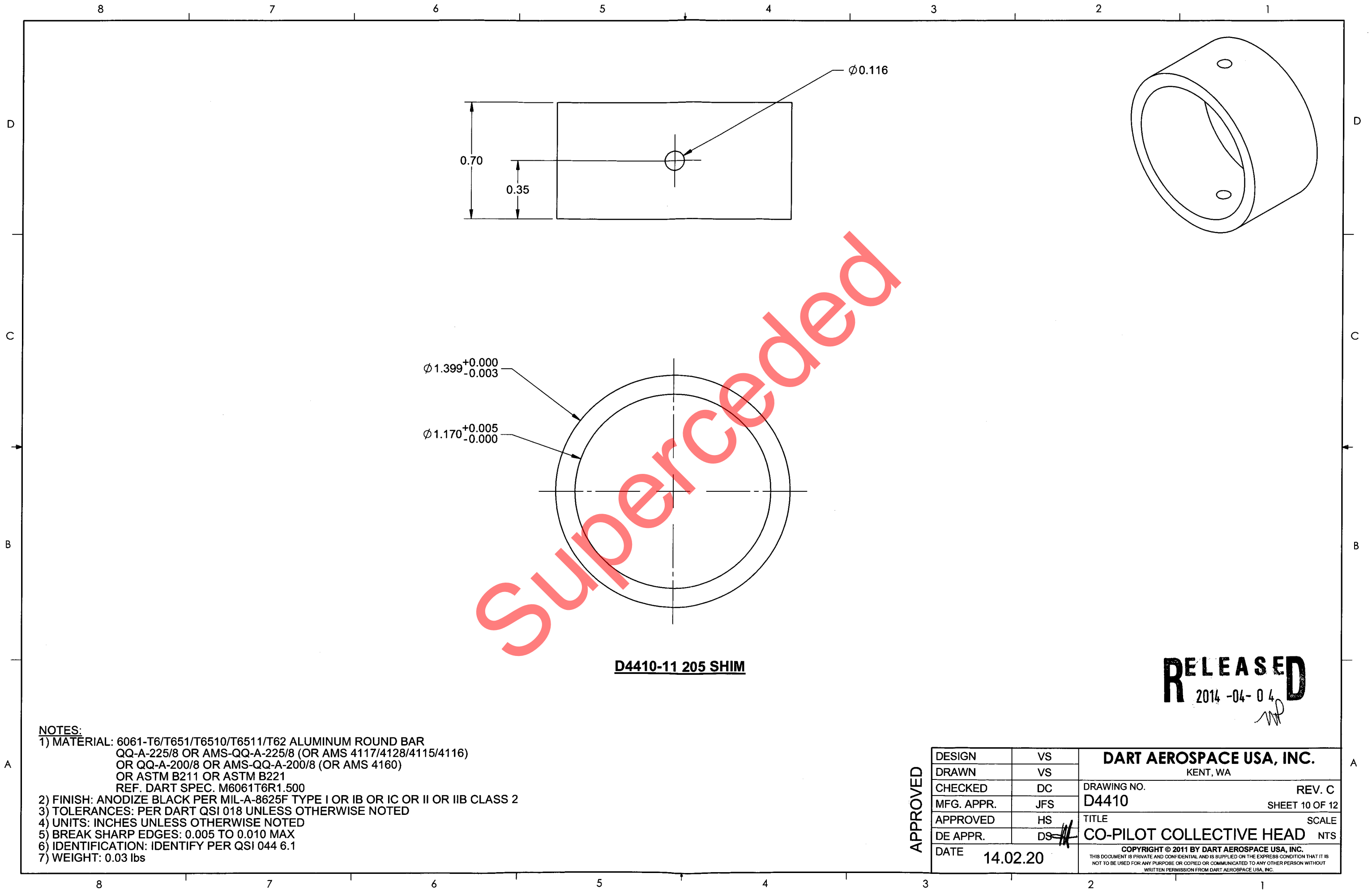
D4410-7 CONDUIT

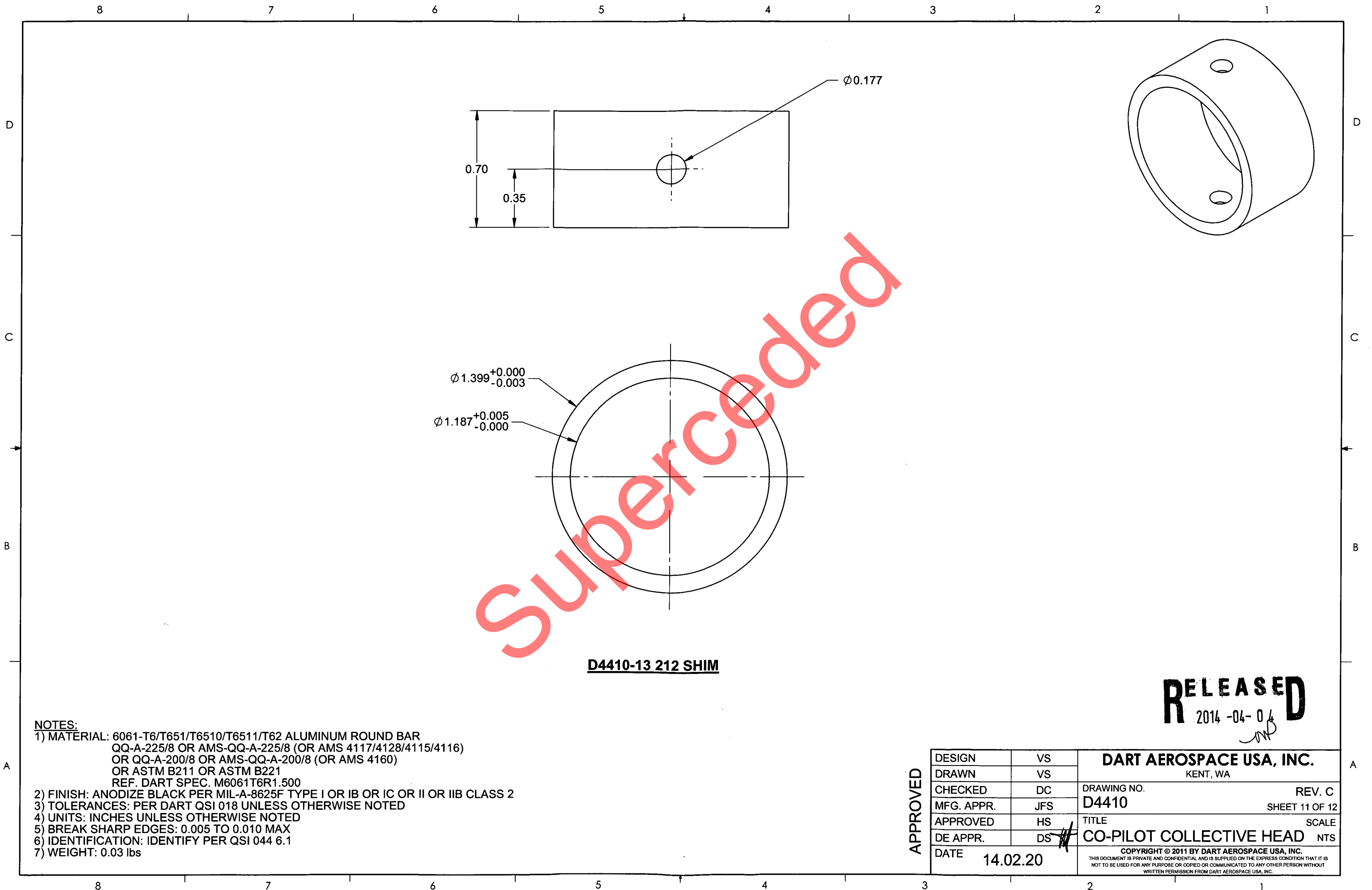
RELEASED
2014-04-04
[Signature]

- NOTES:**
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T60.625W.050
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
7) WEIGHT: 0.17 lbs

APPROVED	DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
	DRAWN	VS		
	CHECKED	DC	DRAWING NO.	REV. C
	MFG. APPR.	JFS	D4410	SHEET 8 OF 12
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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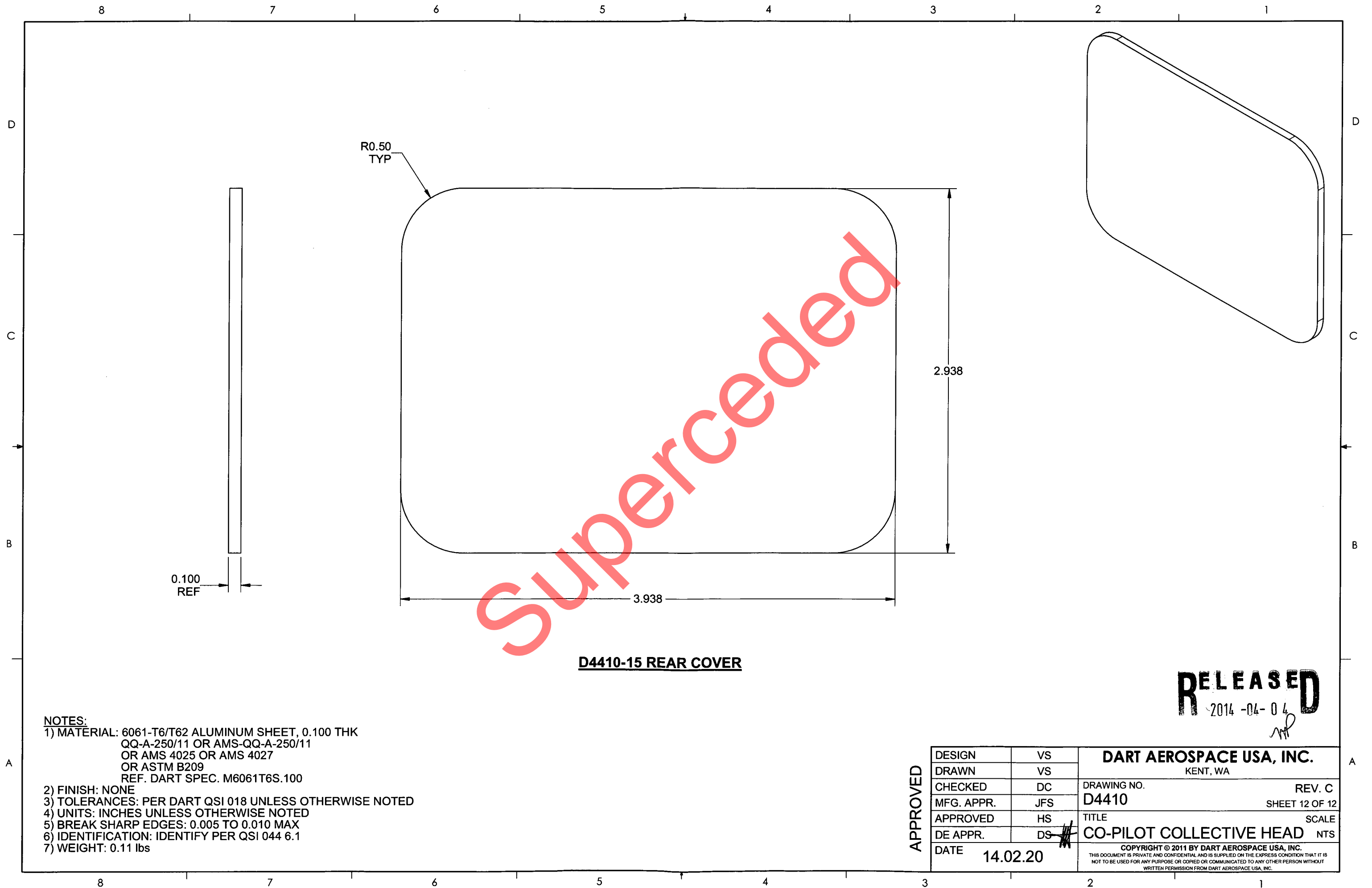
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR
QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6R1.500
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.03 lbs

RELEASED
2014-04-04

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DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4410	SHEET 11 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.100 THK
QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF. DART SPEC. M6061T6S.100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

D4410-15 REAR COVER

RELEASED
2014-04-04
mp

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DESIGN	VS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	VS		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4410	SHEET 12 OF 12
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CO-PILOT COLLECTIVE HEAD	NTS
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